

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																					

Work Order ID 133503

133503

Page 2

Monday, June 08, 2015 4:12:50 PM

Item ID: D2933-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Saddle LH In, 206

Start Date: 6/08/15 Start Qty: 4.00 *4* Cust Item ID:

Required Date: 6/08/15 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				4	0		DAS 44 9-89 15/08/12
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				(4)	0		15/08/13
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4	0		15/08/13
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:45 AM FINISH TIME: 11:55 AM								

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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		OTHER : _____			

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/08/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 6/08/15 **Req'd Qty:** 4.00 ***/***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC3- Inspect Part Finish

0.00

160

OC

Memo

0.00

Quality Control

**DAS
26
9-89**

170

Identify as per dwg & Stock Location: ST 396

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.01

Quality Control

AUG 14 2015

MF
(5-8-14)

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

Monday, June 08, 2015 4:12:50 PM

Page 1

Work Order ID: 133503

133503

Parent Item: D2933-1

D2933-1

Parent Item Name: Saddle LH In, 206

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	19.0000	1	4			
										**	<u>15/08/11</u>	DAS	
											40		
											9-89		

D6101-001

Saddle Billet

Location	Loc Qty	Loc Code
MAT042	16	
→ 129986	16	
MAT045	3	
125829	3	

→ 132708

~~3~~

3

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DART AEROSPACE LTD		Work Order: 133503
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.126	.126	.125	.125	
B	0.100	0.140		.126	.126	.125	.125	
C	0.100	0.140		.120	.118	.119	.116	
D	0.210	0.230		.227	.225	.225	.222	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.511	.514	.511	.511	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.258	.258	.258	.258	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.238	.238	.235	.238	
N	0.100	0.140		.125	.125	.124	.124	
O	0.540	0.560		.551	.551	.551	.551	
P	0.490	0.510		.503	.502	.502	.501	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.490	2.490	2.490	2.490	
S	0.240	0.270		.254	.255	.255	.254	
T	0.100	0.180		.140	.140	.140	.140	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.125	1.145		1.1367	1.1374	1.1370	1.1360	
Y	1.565	1.585		1.5743	1.5732	1.5737	1.5744	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								

Accept/Reject

DAS

Measured by: 40

Date: 15/08/11

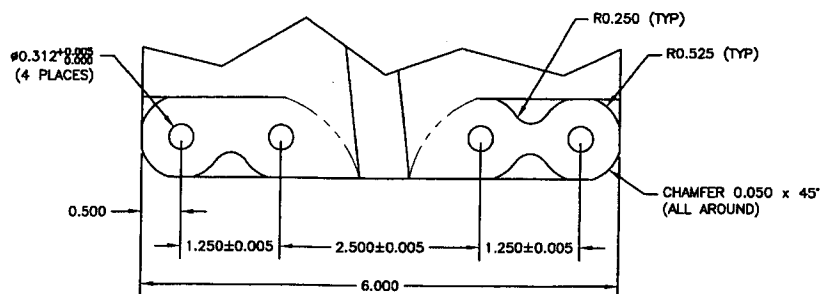
Audited by: 9-59 FK

Date: 15/08/12

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

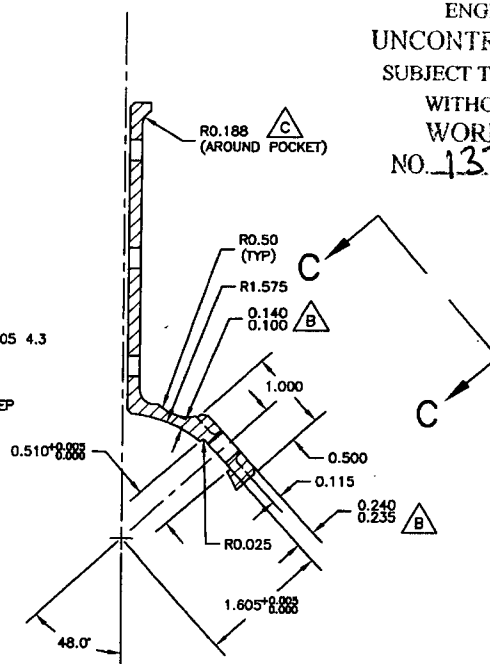


VIEW C-C

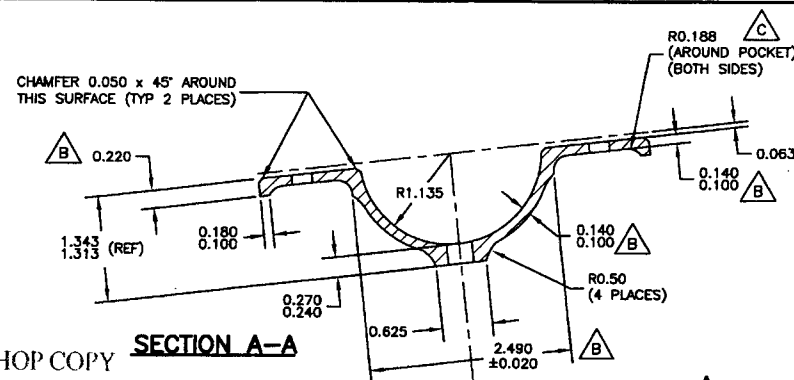
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

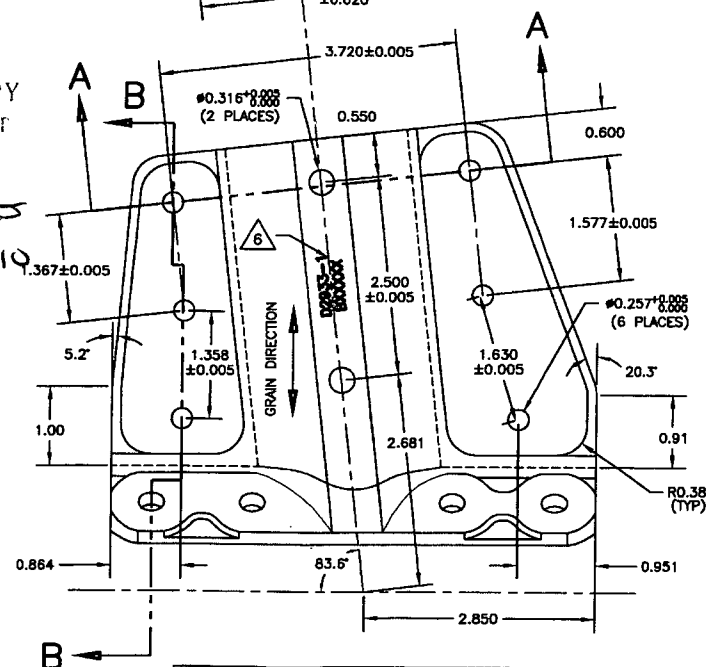


SECTION B-B



SECTION A-A

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 WITHOUT NOTICE
 WORK ORDER
 NO. 133503.MLS
 15-06-19



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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 DART AEROSPACE USA, INC.

DART AEROSPACE USA, INC.
 BELLEVUE, WA

DRAWING NO. D2933

REV. C

SHEET 1 OF 1

SCALE

2:3

FILED

07-02-12